

FIG.24

"rows"

"columns"

"further division" (columns)

"first division" (rows)

"further division" (rows)

"first division" (columns)

HT	HY	MACHINING SPEED	EDGE THICKNESS	1			
				THICK	THIN	THICK	THIN
HT1	CIRCUMFERENTIAL SURFACE ROUGH MACHINING	FEED SPEED (LENS SHAFT TURNING SPEED)	TOOL TURNING SPEED	02	02	03	04
HT2	CIRCUMFERENTIAL SURFACE FINISHING MACHINING	FEED SPEED (LENS SHAFT TURNING SPEED)	TOOL TURNING SPEED	05	05	05	05
HT3	GROOVE MACHINING	FEED SPEED (LENS SHAFT TURNING SPEED)	TOOL TURNING SPEED	02	02	04	04
HT4	CHAMFERING	FEED SPEED (LENS SHAFT TURNING SPEED)	TOOL TURNING SPEED	02	02	04	04